

# Work Order ID 66891-2

Wednesday, March 02, 2011 10:11:29 AM



Page 1

Item ID: D3243-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

ME

Date: 11-03-02 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3243

Rev A

110

0.00



Waterjet

HAAS CNC VERTICAL MACHINING #1

FLOW CNC Waterjet

Memo

0.00

B11-3-3

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B11-3-3

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11 03 03 10

150

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3243

SD 11/03/04

10

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SD 11/03/04

4/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Bracket Assembly

Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 11-3-7.

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D3343

ES 11/03/10 (4)

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 03 10 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Bracket Assembly

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Start Date: 3/2/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

*M112588*

Memo

0.00

Powder Coating

\*\*\*\*\*Mask Holes\*\*\*\*\*

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*10:45*  
*350°*  
*11:15*

*4 BR 11-3-15*

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*4 624 u/03/15*

220

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*11/3/15* *QD*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/11

mk

11-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 02, 2011 10:11:26 AM

Page 1

Work Order ID: 66891

Parent Item: D3243-041

Parent Item Name: Bracket Assembly



Start Date: 3/2/2011

Required Date: 3/23/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-032-EF  Inserts		Purchased	No			180	Each	26.0000	4	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST285		26							
					110836	26							
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			110	sf	145.5000	0.5499	2.894211			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT		111.6							
					116308	28.6							
					116623	83							
				MAT21		33.9							
					113608	33.9							

*Handwritten:* 3/5/11/10  
M 111341 (15x)

*Handwritten:* 211  
6.  
PB11-3-3

*Handwritten:* (10)

*Handwritten:* 116623

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

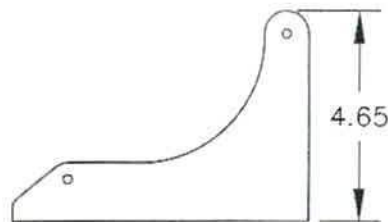
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/  
D3243-041 ASSEMBLY  
SCALE 1:4

# 66891  
INSTALL  
FE-032-EF INSERTS  
(4 PLACES)

2.75<sup>+0.030</sup><sub>0.000</sub>

RELEASED  
04 02 03

8.581  
8.206  
7.706

GRAIN  
DIRECTION

11.920  
11.420

Ø0.201  
(TYP 4  
PLACES)

Ø0.290  
(TYP 4  
PLACES)

1.375

5.273

3.714

4.214  
R0.25 (TYP)

3.339  
R0.38  
(TYP)

5.494

R2.75  
(TYP)

### D3243-041 BRACKET ASSEMBLY (D3243-1 BRACKET)

- 1) MATERIAL: 6061-T6, 0.063 THICK  
(QQ-A-250/11, REF DART SPEC  
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER  
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO  
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

D3243-1  
FLAT PATTERN

R0.50  
(TYP)

0.500  
0.000

0.750  
0.500  
0.000

6.560  
5.810  
5.360

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